

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027218**Date Inspected:** 14-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The QA Inspector randomly observed the following work in progress:

Quality Assurance Inspector (QA) Rene Hernandez was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

West Line

This QA observed, at random intervals, ABF/JV qualified welder Jason Collins #8128 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3010-1. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the "A" deck to close the manway access hole. This work was located at 9W/10W at counterweight side of deck between counterweight and barrier rail. weld identified as number 9W PP84 W5. During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters. Welding parameters were recorded.

This QA observed, at random intervals, ABF/JV qualified welder Mike Jimenez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 13W PP118.5 W3 2 was performed in the flat position from the topside of the "A" deck plate. During welding,

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ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded. Also verified that CU backup strip was secured from top and under deck.

Ultrasonic Testing

This QA performed Ultrasonic Testing (UT) on approximately 10% of welds at the following location and weld numbers: 13W/14W weld no. A4 at 4000mm to 5500mm and weld D3 @ 1090mm.

These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

This weld is a Seismic Performance Critical Member (SPCM) member.

Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on approximately 15% of welds at the following location and weld numbers: 12W/13W weld no. A4 at 3000mm to 4000mm.

These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed no rejectable indications at the time of testing. This QA generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.



Summary of Conversations:

Pertinent conversations are in the body of this report

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene
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Quality Assurance Inspector

Reviewed By:	Levell,Bill
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QA Reviewer
